Dart Aerospace Ltd. Tuesday, 18/12/2007 1:29:56 PM Date User: Linda Lacelle **Process Sheet** : D3183-041 : CC-DAR01 Dart Aerospace Ltd. **Drawing Name** Customer Job Number : 36430 : 10804 **Estimate Number** : D31831 **Part Number** P.O. Number : DISASSEMBLE **Drawing Number** : 18/12/2007 S.O. No. : This Issue : NC **Project Number** Prsht Rev. : MACHINED PARTS : // First Issue Type **Drawing Revision** : 00015 Material **Previous Run** 1 Um: : 25/12/2007 Qty: **Due Date** Written By Checked & Approved By Comment **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: PACKAGING RESOURCE #1 PACKAGING 1 1.0 Comment: PACKAGING RESOURCE #1 L St-12-18 REMOVE FROM STK: 1 X D3183-041 B21893 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 2.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 DISASSEMBLE & RESTOCK: 1 X D3183-1 21893 ∕2 X D3183-5 1x 831835 21884 DISCARD: 23459 D3121-21 D3183-9

3.0 QC21

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



N Q.12.18

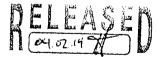
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5/25

| DART AEROSPACE LTD | Work Order: | . 23505 |
|-------------------------------|--------------|-------------|
| Description: Bearing Assembly | Part Number: | D318'3-045 |
| Dwg: D3183 Rev. C | Qty: | 32 Kit(s) |
| , | • | Page 1 of 1 |

| Step | Location | Procedure | Ву | Date | Qty |
|------|----------|--|----------|----------|-----|
| 1 | DC | Issue Traveler Note: Traveler Note: Traveler Note: Traveler | * | 05.0403 | 32 |
| 2 | МС | Turn D3183-9 Cap as per Folio FA388 Material: 81 00 Delrin Rod (M-DELRIN-R1900) Identify as D3183-9 Batch: B 21875 B | K | 05/06/03 | 32 |
| 3 | MC | Deburr N A | 1 | | |
| 4 | QC2 | Inspect parts as they come off the CNC machine | 71 |) | |
| 5 | QC8 | Second check | | | |
| 6 | GA | Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183. Pick: Oty Part Number Description D3183-5 Bearing Description D3183-5 Bearing Description D3183-5 Bearing Description D3183-5 Bearing | Er | 05/06/03 | 32 |
| 7 | QC5 | Inspect work to Step 6 | E | 05.06.06 | 32 |
| 8 | ST | Identify and Stock | CX | 05/06/06 | 32 |
| 9 | AC | Cost / part | R. | 05/06/01 | 32 |
| 10 | DC | Close W/O & .4/3 Inspect Level 21 | W | US.06.08 | 32 |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|-----------|------------|----------|
| Α | 04.02.18 | New issue | KJ/DS | |



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| Step Location Procedure By Date Qty | | | | <u> </u> | rage 1 01 1 | · |
|--|----------|--------------|---|----------|-------------|-------------|
| DC | Step | Location | Procedure | By | Dato | Oty |
| Cut (1) blank per D3183-041 & (1) blank per D3183-042 | 1 | DC | Issue Traveler | M | 1 | |
| Cut blanks (2.00" x 1.50") x 4.30" Long Bar Material: 17.4 SS per AMS 5604/5643 (MT7-4-B2.000x01.500) 3 MV Machine D3183-1 as per Folio FA320 and Dwg D3183 4 QC2 Inspect parts as they come off the CNC machine 5 MV Machine D3183-2 as per Folio FA320 and Dwg D3183 6 QC2 Inspect parts as they come off the CNC machine 7 MV Deburr Break all sharp edges 0.005 to 0.015 8 MV Scribe batch number to D3183-1 & D3183-2 as per Dwg D3183 9 QC5 Second check D3183-1 and D3183-2 10 GA Assemble D3183-041 as per Dwg D3183 Pick: Qty Part Number Description Batch 2 D3183-8 c+5 Bearing 42 SD SCCCO 2 D3121-7 Washer 2 M324684-S50 Screw 2 D3183-7 Washer 4 D3183-8 c+5 Bearing 8 235-95 2 D3121-2 D313-7 Washer 2 D3183-7 Washer 2 M324684-S50 Screw 2 D3183-7 Washer 2 D3183-7 Washer 2 D3183-7 Washer 2 D3183-7 Washer 3 MS24684-S50 Screw 2 D3121-2 L b-1-4 B234-59 B 12 QC5 Inspect work to Step 10 & 11 13 ST Identify and Stock in Spacedoor cell D3183-041 Qty 5 C3 D510c/o7 5 14 AC Parts to Stock and Prorate Cost to parts per Step 13 15 DC Close W/O / 36.57 / 57.34 MAC Parts to Stock and Prorate Cost to parts per Step 13 MAC Close W/O / 36.57 / 57.34 MAC Close W/O / 36.57 / 57.34 MAC Darks to Stock and Prorate Cost to parts per Step 13 MAC Close W/O / 36.57 / 57.34 MAC Darks to Stock and Prorate Cost to parts per Step 13 MAC Darks to Stock and Prorate Cost to parts per Step 13 MAC Close W/O / 36.57 / 57.34 | 2 | MV | Cut (1) blank per D3183 041 8 (4) blank per D3483 049 | 40 | 04.11. 26 | 5 |
| Material: 17-4 SS per AMS 5604/5643 Material: 17-4 SS per AMS 5604/5643 Mathine D3183-1 as per Folio FA320 and Dwg D3183 C5-02-07 S. | - | | Cut blanks (2.00" x 1.50") x 4.30" Long Bar | | | |
| MV Machine D3183-1 as per Folio FA320 and Dwg D3183 | | | Material: 17-4 SS per AMS 5604/5643 | | | |
| MV Machine D3183-1 as per Folio FA320 and Dwg D3183 | | | <u> </u> | 50 | cata trace | <u>سے</u> ا |
| Second check D3183-1 and D3183-2 Sile Color | 3 | MV | Machine D3183-1 as per Folio FA320 and Dwg D3183 | 7 | 1 | - |
| 5 MV Machine D3183-2 as per Folio FA320 and Dwg D3183 6 QC2 Inspect parts as they come off the CNC machine 7 MV Deburr Break all sharp edges 0.005 to 0.015 8 MV Scribe batch number to D3183-1 & D3183-2 as per Dwg D3183 9 QC5 Second check D3183-1 and D3183-2 10 GA Assemble D3183-041 as per Dwg D3183 Pick: Qty Part Number Description Batch 2 B949-4-17 Washer 2 B949-4-17 Washer 2 B3183-7 Washer 2 M52494-550 Scriew 2 B3183-7 Washer 2 M52494-4-17 Washer 4 D3183-10-45 Bearing 40-5. Qty Part Number Description Batch 2 B3183-7 Washer 2 M52494-4-17 Washer 4 D3183-10-45 Bearing 40-5. Qty Part Number Description Batch 2 M524964-4-50 Scriew 2 D3121-21 bold B23459 B 12 QC5 Inspect work to Step 10 & 11 13 ST Identify and Stock in Spacedoor cell D3183-041 Qty 5 D3183-042 Qty 5 C J 55/06/07 5 14 AC Parts to Stock and Prorate Cost to parts per Step 13 Cost / part 19-2-2-2-3-2-3-3-3-4 Washer Step 13 Cost / part 19-2-2-3-3-4 Washer Step 13 Cost / part 19-2-2-3-4 Washer Step 13 Cost / part 19-2-2-4 Washer Step 13 | Λ | 002 | Inspect parts on the control of the ONO | | US.06.09 | 5 |
| Mode Machine D3183-2 as per Folio FA320 and Dwg D3183 | 7 | QUZ | Inspect parts as they come on the CNC machine | 7// | 5. 12 n2/ | |
| 10 GA | 5 | MV | Machine D3183-2 as per Folio FA320 and Dwg D3183 | 1 | MD.0001 | <u> </u> |
| 10 GA | | 0.00 | | R | 05.06.06 | 5 |
| Break all sharp edges 0.005 to 0.015 | , 6 | QC2 | Inspect parts as they come off the CNC machine | | | |
| Break all sharp edges 0.005 to 0.015 | 7 | MV | Deburr | <u>C</u> | 05.06.06 | 2 |
| 8 MV Scribe batch number to D3183-1 & D3183-2 as per Dwg D3183 9 QC5 Second check D3183-1 and D3183-2 10 GA Assemble D3183-041 as per Dwg D3183 Pick: Qty Part Number Description Batch 2 D3183-7 Washer 2 MS24894-50 Screw 2 SID SCREW 2 D3183-7 Washer 2 MS24894-50 Screw 2 SID SCREW 2 D3183-7 Washer 2 MS24894-50 Screw 3 SID SCREW 2 D3183-7 Washer 2 D3183-9-0-0-5 Bearing 8 23505 12 QC5 Inspect work to Step 10 & 11 13 ST Identify and Stock in Spacedoor cell D3183-041 Qty 5 D3183-042 Qty 5 Cd 05/06/07 5 14 AC Parts to Stock and Prorate Cost to parts per Step 13 Cost / part 94-3-5 94-3-5 97-3-4 15 DC Close W/O / 36-0-7 / S 97-3-4 | | | | F | 05 OF N | 5 |
| Second check D3183-1 and D3183-2 | 8 | MV | Scribe batch number to D3183-1 & D3183-2 as per Dwg D3183 | | 1 | |
| 10 GA | <u> </u> | 005 | Second short D2422 4 LD2422 | | 5.02.0f | <u>گ</u> |
| Assemble D3183-041 as per Dwg D3183 Pick: Qty Part Number Description Washer # D3183-8-c45 Bearing 425. 2 D3183-7 Washer 2 M524894-859 Screw 2 D3183-042 as per Dwg D3183 Pick: Qty Part Number Description Batch Qty Part Number Description Batch 2 D3121-17 Washer 2 D3121-17 Washer 2 D3121-17 Washer 2 D3121-2 I bol-+ B23459 B D5.02.66 S 12 QC5 Inspect work to Step 10 & 11 13 ST Identify and Stock in Spacedoor cell D3183-041 Qty D3183-042 Qty C32 Qty D3183-042 Qty C32 Qty D3183-042 Qty C32 Qty C32 Qty D3183-042 Qty D31 | 9 | QCS | Second check D3183-1 and D3183-2 | 96 | | / |
| Pick: Qty Part Number Description Batch 2 D3183-7 Washer 2 D3183-7 Washer 2 M524694-850 Screw 2 D3183-7 Washer 2 D3183-7 Washer 2 D3121-17 Washer 2 D3121-17 Washer 2 D3121-17 Washer 2 D3121-21 bal + B23459 B D5.04.66 S D3121-21 bal + B23459 B D5.04.66 S D3183-042 Qty | 10 | GA | Assemble D3183-041 as per Dwg D3183 | الاد. | 02000 | 2 |
| 2 | | | Pick: | | | |
| ## D3183-8 045 Bearing 405. D3183-7 | _ | 世 | | | | |
| 2 D3183-7 Washer 2 MS24694-S50 Screw 2 SI2 - 2 Point 32533 11 GA Assemble D3183-042 as per Dwg D3183 Pick: Qty Part Number Description Batch 2 D3121-17 Washer 2 D3183-7 Washer 2 MS24694-S50 Screw 2 D3121-21 bol+ B23459 B 12 QC5 Inspect work to Step 10 & 11 13 ST Identify and Stock in Spacedoor cell D3183-041 Qty 5 D3183-042 Qty 5 D3183-042 Qty 5 D3183-042 Qty 5 14 AC Parts to Stock and Prorate Cost to parts per Step 13 Cost / part 9/25 / 39.34 15 DC Close W/O /36.07 /59.34 | اء ا | 26/15 = 2 35 | 14 D0400 # 160 | j | | |
| 11 GA Assemble D3183-042 as per Dwg D3183 Pick: Qty Part Number Description Batch 2 D3121-17 Washer 2 D3121-17 Washer 2 D3183-7 Washer 2 M524694-850 Screw 2 D3121-21 bol+ B723459 B 12 QC5 Inspect work to Step 10 & 11 13 ST Identify and Stock in Spacedoor cell D3183-041 Qty 5 D3183-042 Qty 5 D3183- | 95 | 0 1 | | | 1 | |
| Assemble D3183-042 as per Dwg D3183 Pick: Qty Part Number Description Batch 2 D3121-17 Washer 2 D3183-7 Washer 2 MS24694-S50 Screw 2 D3121-21 bol+ B73459 B 12 QC5 Inspect work to Step 10 & 11 13 ST Identify and Stock in Spacedoor cell D3183-041 Qty 5 D3183-042 Qty 5 Cost / part 94-35 15 DC Close W/O /36.07 /59.34 | | | | | | |
| Pick: Qty Part Number Description Batch 2 D3121-17 Washer 2 D3183-7 Washer 2 M624694-850 Screw 2 D3121-2 bol+ 6723459 B 12 QC5 Inspect work to Step 10 & 11 13 ST Identify and Stock in Spacedoor cell D3183-041 Qty 5 D3183-042 Qty 5 Pick: Qty Part Number Description Batch 2 D3183-7 Washer 2 M624694-850 Screw 2 D3121-2 bol+ 6723459 B D5 05 06 6 5 D5 05 06 6 5 D5 06 06 5 | 11 | GA | | -617 | 05 cool | 5 |
| OS OS OS OS OS OS OS OS | 1 1 | GA . | Pick: | | | |
| 2 D3121-17 Washer A D3183-8-045 Bearing 2 D3183-7 Washer 2 MS24694-S50 Screw 2 D5121-21 bol-1 B73459 B 12 QC5 Inspect work to Step 10 & 11 13 ST Identify and Stock in Spacedoor cell D3183-041 Qty D3183-042 Qty 5 C3 D5/06/07 5 14 AC Parts to Stock and Prorate Cost to parts per Step 13 Cost / part 94.35 94.35 15 DC Close W/O /36.07 /59.34 | 7 | | 0. 5 | } | | ļ |
| 2 D3183-7 Washer 2 M624694-S50 Screw 2 D3121-21 bol+ B734598 12 QC5 Inspect work to Step 10 & 11 13 ST Identify and Stock in Spacedoor cell D3183-041 Qty 5 D3183-042 Qty 5 14 AC Parts to Stock and Prorate Cost to parts per Step 13 Cost / part 94.35 94.35 15 DC Close W/O /36.07 /59.34 | · + | 115 | 2 D3121-17 Washer | | | ŀ |
| 2 MS24694-350 Screw 2 DS121-21 bol+ B7234598 | 05 | ou. 2 Z | <u> </u> | | } | |
| 2 05121-21 bol+ B734598 | | | | 1 | | _ |
| 12 QC5 Inspect work to Step 10 & 11 13 ST Identify and Stock in Spacedoor cell D3183-041 Qty 5 D3183-042 Qty 5 Cd 05/06/07 5 14 AC Parts to Stock and Prorate Cost to parts per Step 13 Cost / part 94.35 94.35 15 15 DC Close W/O /36.07 /59.34 | | 4, | | 19 | 05.066 | 51 |
| 14 AC Parts to Stock and Prorate Cost to parts per Step 13 Cost / part 94.25 15 DC Close W/O /36.07 /59.34 | 12 | QC5 | | | | |
| 14 AC Parts to Stock and Prorate Cost to parts per Step 13 Cost / part 94.25 15 DC Close W/O /36.07 /59.34 | 12 | CT | | in | 65/06/00) | -5 |
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| 15 DC Close W/O /36.07 /59.34 | 14 | AC | * | C Zz, c | 5/06/07 | 5 |
| 15 DC Close W/O /36.07 /59.39 | ' | ^\ | Cost / part 94 3 94. 3 94. 3 9 9 Step 13 | 46 | sh/12. | - |
| Inspect Level 21 47 05.06.15 5 | 15 | DC | | 101 | 100/10 1 | |
| | | | Inspect Level 21 | KAI | 5.06.15 | 5 |

| Rev | Date | Change | Revised By | Approved |
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| A | 03.03.28 | New issue | KJ/RF | AP |

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03.10.02

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